



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**D350-636-011**  
**Job Sheet 196900**



**Part No:** D350-636-011

**Job Qty:** 1 pcs

**Part Name:** Skidtubes LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 6/24/19

**Job Tracking No:**

**Due Date:** 7/20/19

**Created By:** Kimberley Guerin

**Type:** Stock

**Description:**

**Note:** D2750-041 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343  
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP  
Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22  
revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-  
594 DD VERF:JLM IPP REV:S 18.11.09 AS PER ECN18-830 DD VERF:JFS

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation     | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off          |
|-------|---------------|----------|------------|----------|-----------|---------|-----------------------|-----------|-------------------|
|       |               |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                   |
| 110   | Skidtubes - 1 | 1<br>pcs | 7/20/19    |          | 0.00      | 4.55    | Skidtubes - 1         |           |                   |
|       |               |          |            |          |           |         | Skidtubes - 2         |           |                   |
|       |               |          |            |          |           |         | Skidtubes - 3         |           |                   |
|       |               |          |            |          |           |         | Skidtubes - 4         |           |                   |
|       |               |          |            |          |           |         | Skidtubes - 5         |           |                   |
|       |               |          |            |          |           |         | Skidtubes - 6         |           |                   |
|       |               |          |            |          |           |         | Skidtubes - 7         |           |                   |
| 120   | QC 10         | 1<br>pcs | 7/20/19    |          | 0.00      | 0.00    | QC 10 - 10            |           | DAS<br>43<br>9-89 |
|       |               |          |            |          |           |         | QC 10 - 18            |           |                   |
|       |               |          |            |          |           |         | QC 10 - 24            |           |                   |
|       |               |          |            |          |           |         | QC 10 - 43            |           |                   |
|       |               |          |            |          |           |         | QC 10 - 50            |           |                   |
|       |               |          |            |          |           |         | QC 10 - 58            |           |                   |
|       |               |          |            |          |           |         | QC 10 - 9             |           |                   |
| 130   | QC 5          | 1<br>pcs | 7/20/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 12             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 17             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 18             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 19             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 22             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 24             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 3              |           |                   |
|       |               |          |            |          |           |         | QC 5 - 43             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 49             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 51             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 58             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 68             |           |                   |
|       |               |          |            |          |           |         | QC 5 - 9              |           |                   |

Plex 6/24/19 3:56 PM Dart.Guer

|                                   |          |         |           |                           |   |
|-----------------------------------|----------|---------|-----------|---------------------------|---|
| 140 Handfinish - 1-1 Chemical-B4B | 1<br>pcs | 7/20/19 | 0.00 0.93 | QC 5 - 50                 |   |
|                                   |          |         |           | QC 5 - 30                 |   |
|                                   |          |         |           | QC 5 - 40                 |   |
|                                   |          |         |           | Handfinish - 1 - 1 - B4B  | ✓ |
|                                   |          |         |           | Handfinish - 1 - 2 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 3 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 4 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 5 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 6 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 7 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 8 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 9 - B4B  |   |
|                                   |          |         |           | Handfinish - 1 - 10 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 11 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 12 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 13 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 14 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 15 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 16 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 17 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 18 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 19 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 20 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 21 - B4B |   |
|                                   |          |         |           | Handfinish - 1 - 22 - B4B |   |
| 150 QC 7                          | 1<br>pcs | 7/20/19 | 0.00 0.00 | QC 7 - 10                 |   |
|                                   |          |         |           | QC 7 - 13                 |   |
|                                   |          |         |           | QC 7 - 14                 |   |
|                                   |          |         |           | QC 7 - 15                 |   |
|                                   |          |         |           | QC 7 - 17                 |   |
|                                   |          |         |           | QC 7 - 18                 |   |
|                                   |          |         |           | QC 7 - 19                 |   |
|                                   |          |         |           | QC 7 - 2                  |   |
|                                   |          |         |           | QC 7 - 28                 |   |
|                                   |          |         |           | QC 7 - 3                  |   |
|                                   |          |         |           | QC 7 - 30                 |   |
|                                   |          |         |           | QC 7 - 34                 |   |
|                                   |          |         |           | QC 7 - 36                 |   |
|                                   |          |         |           | QC 7 - 37                 |   |
|                                   |          |         |           | QC 7 - 41                 |   |
|                                   |          |         |           | QC 7 - 47                 |   |
|                                   |          |         |           | QC 7 - 48                 |   |
|                                   |          |         |           | QC 7 - 51                 |   |
|                                   |          |         |           | QC 7 - 58                 |   |
|                                   |          |         |           | QC 7 - 59                 |   |
|                                   |          |         |           | QC 7 - 60                 |   |
|                                   |          |         |           | QC 7 - 9                  |   |
|                                   |          |         |           | QC 7 - 68                 |   |

DAS  
40  
9-89

JUL 19 2019

M 19-7-7

TUE 9-10-2019

Rosales, Oscar

TW/LSB

|                                   |       |         |           |                          |                               |
|-----------------------------------|-------|---------|-----------|--------------------------|-------------------------------|
|                                   |       |         |           | QC 7 - 50                |                               |
|                                   |       |         |           | QC 7 - 67                |                               |
|                                   |       |         |           | QC 7 - 40                |                               |
|                                   |       |         |           | QC 7 - 24                |                               |
|                                   |       |         |           | QC 7 - 43                |                               |
|                                   |       |         |           | QC 7 - 61                |                               |
|                                   |       |         |           | QC 7 - 81                |                               |
| 160 Skidtubes - 2 - B4B           | 1 pcs | 7/20/19 | 0.00 4.55 | Skidtubes - 1 - B4B      | DD                            |
|                                   |       |         |           | Skidtubes - 2 - B4B      |                               |
|                                   |       |         |           | Skidtubes - 3 - B4B      |                               |
|                                   |       |         |           | Skidtubes - 4 - B4B      | TF                            |
|                                   |       |         |           | Skidtubes - 5 - B4B      | BE                            |
|                                   |       |         |           | Skidtubes - 6 - B4B      |                               |
|                                   |       |         |           | Skidtubes - 7 - B4B      |                               |
| 170 QC 10                         | 1 pcs | 7/20/19 | 0.00 0.00 | QC 10 - 10               |                               |
|                                   |       |         |           | QC 10 - 18               |                               |
|                                   |       |         |           | QC 10 - 24               |                               |
|                                   |       |         |           | QC 10 - 43               |                               |
|                                   |       |         |           | QC 10 - 50               | DAS<br>JUL 30 2019 50<br>9-89 |
|                                   |       |         |           | QC 10 - 58               |                               |
|                                   |       |         |           | QC 10 - 9                |                               |
| 180 QC 5                          | 1 pcs | 7/20/19 | 0.00 0.00 | QC 5 - 10                |                               |
|                                   |       |         |           | QC 5 - 12                |                               |
|                                   |       |         |           | QC 5 - 17                |                               |
|                                   |       |         |           | QC 5 - 18                |                               |
|                                   |       |         |           | QC 5 - 19                |                               |
|                                   |       |         |           | QC 5 - 22                |                               |
|                                   |       |         |           | QC 5 - 24                |                               |
|                                   |       |         |           | QC 5 - 3                 |                               |
|                                   |       |         |           | QC 5 - 43                |                               |
|                                   |       |         |           | QC 5 - 49                |                               |
|                                   |       |         |           | QC 5 - 51                |                               |
|                                   |       |         |           | QC 5 - 58                | DAS<br>JUL 30 2019 68<br>9-89 |
|                                   |       |         |           | QC 5 - 68                |                               |
|                                   |       |         |           | QC 5 - 9                 |                               |
|                                   |       |         |           | QC 5 - 50                |                               |
|                                   |       |         |           | QC 5 - 30                |                               |
|                                   |       |         |           | QC 5 - 40                |                               |
| 190 Handfinish - 2-1 Pressure-B4B | 1 pcs | 7/20/19 | 0.00 0.33 | Handfinish - 2 - 1 - B4B |                               |
|                                   |       |         |           | Handfinish - 2 - 2 - B4B | JUL 31 2019                   |
|                                   |       |         |           | Handfinish - 2 - 3 - B4B |                               |
|                                   |       |         |           | Handfinish - 2 - 4 - B4B |                               |
| 200 Spray Paint - 2 - B4B         | 1 pcs | 7/20/19 | 0.00 0.91 | Spray Paint - 1 - B4B    | RD 19-8-6                     |
|                                   |       |         |           | Spray Paint - 2 - B4B    |                               |
|                                   |       |         |           | Spray Paint - 3 - B4B    |                               |
|                                   |       |         |           | Spray Paint - 4 - B4B    |                               |
| 204 QC 14                         | 1 pcs | 7/20/19 | 0.00 0.00 | QC 14 - 15               | DAS<br>JUL 19-8-6 15<br>9-19  |
|                                   |       |         |           | QC 14 - 2                |                               |
|                                   |       |         |           | QC 14 - 34               |                               |
|                                   |       |         |           | QC 14 - 41               |                               |
|                                   |       |         |           | QC 14 - 51               |                               |
|                                   |       |         |           | QC 14 - 58               |                               |
|                                   |       |         |           | QC 14 - 59               |                               |
|                                   |       |         |           | QC 14 - 9                |                               |
|                                   |       |         |           | QC 14 - 68               |                               |
|                                   |       |         |           | QC 14 - 40               |                               |
|                                   |       |         |           | QC 14 - 19               |                               |
|                                   |       |         |           | QC 14 - 43               |                               |
|                                   |       |         |           | QC 14 - 24               |                               |

|                                    |       |         |            |                                            |           |       |         |           |           |
|------------------------------------|-------|---------|------------|--------------------------------------------|-----------|-------|---------|-----------|-----------|
|                                    |       |         | QC 14 - 61 |                                            |           |       |         |           |           |
|                                    |       |         | QC 14 - 81 |                                            |           |       |         |           |           |
| 230 Handfinish - 4-1-Assembly-B4B  | 1 pcs | 7/20/19 | 0.00 0.93  | Handfinish - 4 - 1 - B4B                   | KL 14-9-6 |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 10 - B4B                  |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 11 - B4B                  |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 12 - B4B                  |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 13 - B4B                  |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 14 - B4B                  |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 15 - B4B                  |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 2 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 3 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 4 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 5 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 6 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 7 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 8 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | Handfinish - 4 - 9 - B4B                   |           |       |         |           |           |
|                                    |       |         |            | 240 QC 5                                   |           | 1 pcs | 7/20/19 | 0.00 0.00 | QC 5 - 10 |
|                                    |       |         |            |                                            |           |       |         |           | QC 5 - 12 |
| QC 5 - 17                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 18                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 19                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 22                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 24                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 3                           |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 43                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 49                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 51                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 58                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 68                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 9                           |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 50                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 30                          |       |         |            |                                            |           |       |         |           |           |
| QC 5 - 40                          |       |         |            |                                            |           |       |         |           |           |
| 250 Packaging 1-1 - Pick Kit - B4B | 1 pcs | 7/20/19 | 0.00 0.00  | Packaging 1 - 1 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 2 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 3 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 4 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 5 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 6 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 7 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 8 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 9 - B4B                      |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 10 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 11 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 12 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 13 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 14 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 15 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 16 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 17 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 18 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 19 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Packaging 1 - 20 - B4B                     |           |       |         |           |           |
|                                    |       |         |            | Plex 6/24/19 3:56 PM Dart.Guerin.Kimberley |           |       |         |           |           |

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|     |                             |     |         |                        |                        |
|-----|-----------------------------|-----|---------|------------------------|------------------------|
|     |                             |     |         | Packaging 1 - 21 - B4B |                        |
|     |                             |     |         | Packaging 1 - 22 - B4B |                        |
|     |                             |     |         | Packaging 1 - 23 - B4B |                        |
|     |                             |     |         | Packaging 1 - 24 - B4B |                        |
|     |                             |     |         | Packaging 1 - 25 - B4B |                        |
|     |                             |     |         | Packaging 1 - 26 - B4B |                        |
|     |                             |     |         | Packaging 1 - 27 - B4B |                        |
|     |                             |     |         | Packaging 1 - 28 - B4B |                        |
|     |                             |     |         | Packaging 1 - 29 - B4B |                        |
|     |                             |     |         | Packaging 1 - 30 - B4B |                        |
|     |                             |     |         | Packaging 1 - 31 - B4B |                        |
|     |                             |     |         | Packaging 1 - 32 - B4B |                        |
|     |                             |     |         | Packaging 1 - 33 - B4B |                        |
|     |                             |     |         | Packaging 1 - 34 - B4B |                        |
|     |                             |     |         | Packaging 1 - 35 - B4B |                        |
|     |                             |     |         | Packaging 1 - 36 - B4B |                        |
| 260 | QC 4                        | 1   | 7/20/19 | 0.00 0.00              | QC 4 - 28              |
|     |                             | pcs |         |                        | QC 4 - 58              |
|     |                             |     |         |                        | QC 4 - 69              |
|     |                             |     |         |                        | QC 4 - 9               |
|     |                             |     |         |                        | QC 4 - 46              |
|     |                             |     |         |                        | QC 4 - 68              |
|     |                             |     |         |                        | QC 4 - 72              |
|     |                             |     |         |                        | QC 4 - 74              |
|     |                             |     |         |                        | QC 4 - 75              |
| 270 | Packaging 3-1 - Stock - B4B | 1   | 7/20/19 | 0.00 0.00              | Packaging 3 - 1 - B4B  |
|     |                             | pcs |         |                        | Packaging 3 - 2 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 3 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 4 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 5 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 6 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 7 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 8 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 9 - B4B  |
|     |                             |     |         |                        | Packaging 3 - 10 - B4B |
|     |                             |     |         |                        | Packaging 3 - 11 - B4B |
|     |                             |     |         |                        | Packaging 3 - 12 - B4B |
|     |                             |     |         |                        | Packaging 3 - 13 - B4B |
|     |                             |     |         |                        | Packaging 3 - 14 - B4B |
|     |                             |     |         |                        | Packaging 3 - 15 - B4B |
|     |                             |     |         |                        | Packaging 3 - 16 - B4B |
|     |                             |     |         |                        | Packaging 3 - 17 - B4B |
|     |                             |     |         |                        | Packaging 3 - 18 - B4B |
|     |                             |     |         |                        | Packaging 3 - 19 - B4B |
|     |                             |     |         |                        | Packaging 3 - 20 - B4B |
|     |                             |     |         |                        | Packaging 3 - 21 - B4B |
|     |                             |     |         |                        | Packaging 3 - 22 - B4B |
|     |                             |     |         |                        | Packaging 3 - 23 - B4B |
|     |                             |     |         |                        | Packaging 3 - 24 - B4B |
|     |                             |     |         |                        | Packaging 3 - 25 - B4B |
|     |                             |     |         |                        | Packaging 3 - 26 - B4B |
|     |                             |     |         |                        | Packaging 3 - 27 - B4B |
|     |                             |     |         |                        | Packaging 3 - 28 - B4B |
|     |                             |     |         |                        | Packaging 3 - 29 - B4B |
|     |                             |     |         |                        | Packaging 3 - 30 - B4B |
|     |                             |     |         |                        | Packaging 3 - 31 - B4B |
|     |                             |     |         |                        | Packaging 3 - 32 - B4B |
|     |                             |     |         |                        | Packaging 3 - 33 - B4B |
|     |                             |     |         |                        | Packaging 3 - 34 - B4B |

|                  |     |         |           |                        |    |
|------------------|-----|---------|-----------|------------------------|----|
|                  |     |         |           | Packaging 3 - 35 - B4B |    |
|                  |     |         |           | Packaging 3 - 36 - B4B |    |
| 275 DC - 1 - B4B | 1   | 7/20/19 | 0.00 0.00 | DC - 1 - B4B           | 21 |
|                  | pcs |         |           | DC - 2 - B4B           | 21 |
| 280 QC 21 - FG   | 1   | 7/20/19 | 0.00 0.00 | QC 21 - FG - 21        | 21 |
|                  | pcs |         |           | QC 21 - FG - 70        | 21 |
|                  |     |         |           | QC 21 - SA - 53        | 21 |

Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT  
 Descriptions: end per dwg D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. \*\*\*ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE\*\*\* Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 8-Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)  
 130 - (QC5- Inspect part completeness to step on W/O)  
 140 - (Chemical Conversion Coat per QSI005 4.1)  
 150 - (QC7-Inspect Chemical Conversion Coat)  
 160 - (Skid tubes) 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5174342 exp. date: 120819 \*\*\*ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)\*\*\* 8- Weld spacers D3490-1, D3490/3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - (QC10- Inspect visual per QSI004- ground welds)  
 180 - (QC5- Inspect part completeness to step on W/O) \*\*\*VERIFY C'BOARD IS GOOD\*\*\*  
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5198114 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 6198581

204 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - (Assemble as per dwg) 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: \_\_\_\_\_ EXP DATE: \_\_\_\_\_ 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: \_\_\_\_\_ 5- Coat all exposed fasteners with "LPS Procyon" batch: \_\_\_\_\_

240 - (QC5- Inspect part completeness to step on W/O)  
 250 - (Pick Kit)  
 260 - (QC4- 100% Inspect kits for completeness) \*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*  
 270 - (Identify as per dwg & Stock Location: 89.9°) Package as per PPP D350-636-011 Location : FG108  
 275 - (Document Control) record fwd angle: 89.9° Photocopy blue file and type labels per PPP D350-636-011 CHG 008  
 280 - (QC21- Final Inspection - Work Order Release)

| Job BOM         |                     |                |                                    | Container |
|-----------------|---------------------|----------------|------------------------------------|-----------|
| Part / Item     | Component Name      | Quantity       | Operation                          |           |
| D2600-3-BENT-LH | Extrusion Bent LH   | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 011627    |
| D2744           | Cap                 | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | S182077   |
| D2739           | 350 I-Beam          | 1 pcs (1 ea)   | 160-Skidtubes - 2 - B4B            | S192776   |
| D2743           | Crossbolt Spacer    | 8 pcs (8 ea)   | 160-Skidtubes - 2 - B4B            | S193743   |
| D3490-1         | Cross Bolt Spacer   | 4 pcs (4 ea)   | 160-Skidtubes - 2 - B4B            | S182366   |
| D3490-3         | Cross Bolt Spacer   | 4 pcs (4 ea)   | 160-Skidtubes - 2 - B4B            | S186298   |
| AN3C5A          | Bolt                | 34 Ea (34 ea)  | 230-Handfinish - 4-1-Assembly-B4B  | S186611   |
| AN3C6A          | Bolt                | 4 Ea (4 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S167164   |
| AN6C44A         | Bolt                | 4 Ea (4 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S167183   |
| AN8C35A         | Bolt                | 1 Ea (1 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S184402   |
| D2745           | Bushing             | 8 pcs (8 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S167098   |
| D3488-3         | Blade Fitting, LH   | 1 pcs (1 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S206350   |
| D3492-1         | Plug                | 8 pcs (8 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S184950   |
| D3492-3         | Plug                | 8 pcs (8 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S183175   |
| D3537-1         | Wearpad             | 3 pcs (3 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S205437   |
| D3631-1         | Washer              | 8 pcs (8 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S204500   |
| D3791-1         | Wearpad             | 1 pcs (1 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S184192   |
| D3793-1         | Wearplate Fwd       | 1 pcs (1 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S201871   |
| D3793-3         | Wearplate Aft       | 1 pcs (1 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | x S210631 |
| MS21043-6       | Nut                 | 4 Ea (4 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S202007   |
| MS21083C8       | Nut                 | 1 Ea (1 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S166968   |
| NAS1149C0332R   | Washer (AN960C10L)  | 38 Ea (38 ea)  | 230-Handfinish - 4-1-Assembly-B4B  | S167203-1 |
| NAS1149C0832R   | Washer (AN960C816L) | 1 Ea (1 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S193136   |
| NAS1515H3L      | Washer              | 4 Ea (4 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S076017   |
| NAS1611-010     | O-Ring              | 8 Ea (8 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S083559   |
| NAS1611-013     | O-Ring              | 8 Ea (8 ea)    | 230-Handfinish - 4-1-Assembly-B4B  | S057630   |
| ALS4-1032-225   | Rivnut              | 38 Ea (38 ea)  | 230-Handfinish - 4-1-Assembly-B4B  | S170271   |
| D3793-5         | Wearpad             | 1 pcs (1 ea)   | 230-Handfinish - 4-1-Assembly-B4B  | S171300   |
| AN8C21A         | Bolt                | 2 Ea (2 ea) ✓  | 250-Packaging 1-1 - Pick Kit - B4B | S201910   |
| D2741           | Replacement Blade   | 1 pcs (1 ea) ✓ | 250-Packaging 1-1 - Pick Kit - B4B | S184404 ✓ |
| D3493-1         | Washer              | 2 pcs (2 ea) ✓ | 250-Packaging 1-1 - Pick Kit - B4B | S197663 ✓ |
| D3532-1         | Spacer              | 2 pcs (2 ea) ✓ | 250-Packaging 1-1 - Pick Kit - B4B | S199486 ✓ |
| MS21083C8       | Nut                 | 2 Ea (2 ea) ✓  | 250-Packaging 1-1 - Pick Kit - B4B | S163195 ✓ |
| NAS1149D0863J   | Washer              | 2 Ea (2 ea) ✓  | 250-Packaging 1-1 - Pick Kit - B4B | S192757 ✓ |
|                 |                     |                |                                    | S166718 ✓ |

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Tue 9-10-2019

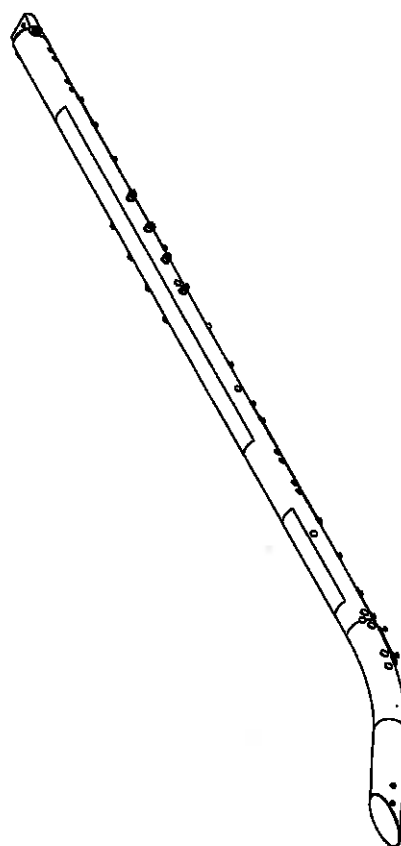
Rosales Oscar

| Job Allocations                    |                 |          |           |           |
|------------------------------------|-----------------|----------|-----------|-----------|
| Operation                          | Component Part  | Required | Inventory | Allocated |
| 110-Skidtubes - 1                  | D2600-3-BENT-LH | 1        | 4         | 0         |
|                                    | D2744           | 1        | 58        | 0         |
|                                    | D2739           | 1        | 9         | 0         |
| 160-Skidtubes - 2 - B4B            | D2743           | 8        | 103       | 0         |
|                                    | D3490-1         | 4        | 169       | 0         |
|                                    | D3490-3         | 4        | 62        | 0         |
|                                    | ALS4-1032-225   | 38       | 916       | 0         |
|                                    | AN3C5A          | 34       | 986       | 0         |
| 230-Handfinish - 4-1-Assembly-B4B  | AN3C6A          | 4        | 153       | 0         |
|                                    | AN6C44A         | 4        | 126       | 0         |
|                                    | AN8C35A         | 1        | 31        | 0         |
|                                    | D2745           | 8        | 72        | 0         |
|                                    | D3488-3         | 1        | 13        | 0         |
|                                    | D3492-1         | 8        | 75        | 0         |
|                                    | D3492-3         | 8        | 31        | 0         |
|                                    | D3537-1         | 3        | 32        | 0         |
|                                    | D3631-1         | 8        | 400       | 0         |
|                                    | D3791-1         | 1        | 6         | 0         |
|                                    | D3793-1         | 1        | 9         | 0         |
|                                    | D3793-3         | 1        | 3         | 0         |
|                                    | D3793-5         | 1        | 4         | 0         |
|                                    | MS21043-6       | 4        | 119       | 0         |
|                                    | MS21083C8       | 1        | 118       | 0         |
|                                    | NAS1149C0332R   | 38       | 5,234     | 0         |
|                                    | NAS1149C0832R   | 1        | 303       | 0         |
|                                    | NAS1515H3L      | 4        | 185       | 0         |
|                                    | NAS1611-010     | 8        | 227       | 0         |
|                                    | NAS1611-013     | 8        | 124       | 0         |
| 250-Packaging 1-1 - Pick Kit - B4B | AN8C21A         | 2        | 145       | 0         |
|                                    | D2741           | 1        | 31        | 0         |
|                                    | D3493-1         | 2        | 29        | 0         |
|                                    | D3532-1         | 2        | 51        | 0         |
|                                    | MS21083C8       | 2        | 118       | 0         |
|                                    | NAS1149D0863J   | 2        | 399       | 0         |
|                                    |                 |          |           |           |
| Part Specifications                |                 |          |           |           |
| Specifications could not be found. |                 |          |           |           |

Plex 6/24/19 3:56 PM Dart.Guerin.Kimberley





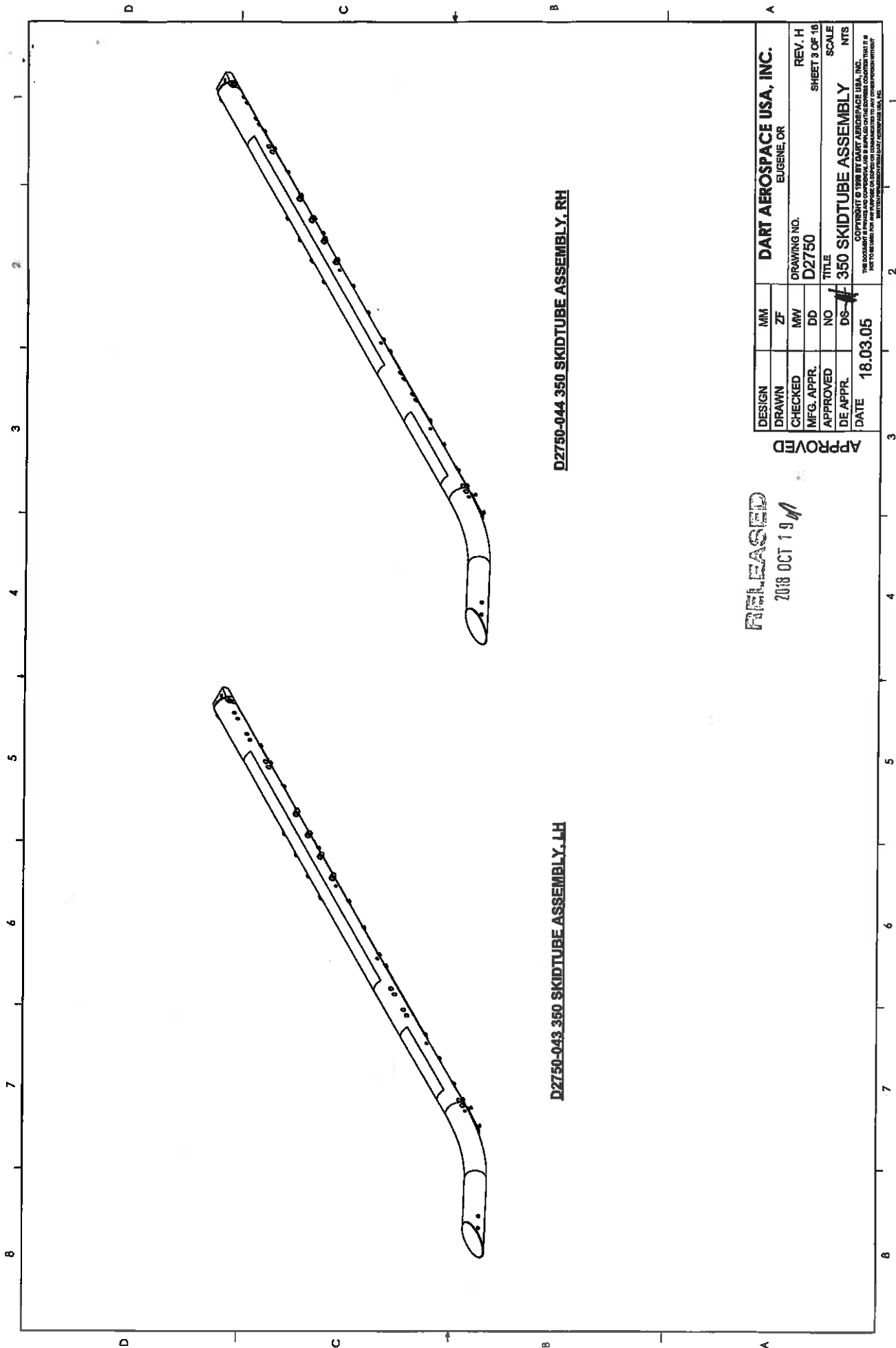


**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

**APPROVED**

|            |          |                                                                                                                                                                                                                                                                                |               |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | MM       | DART AEROSPACE USA, INC.                                                                                                                                                                                                                                                       |               |
| DRAWN      | ZF       | EUGENE, OR                                                                                                                                                                                                                                                                     |               |
| CHECKED    | MMW      | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. H        |
| MFG. APPR. | DD       | D2750                                                                                                                                                                                                                                                                          | SHEET 2 OF 10 |
| APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                          | SCALE         |
| DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                          | NTS           |
| DATE       | 18.03.05 | CONFIRMATION OF THE DRAWING<br>THIS DRAWING IS ISSUED AND ON RECORD TO BE USED FOR CONSTRUCTION TO THE EXTENT OF THE CONTRACT. IF IT IS<br>NOT TO BE USED FOR CONSTRUCTION TO THE EXTENT OF THE CONTRACT, IT IS NOT TO BE USED FOR CONSTRUCTION TO THE EXTENT OF THE CONTRACT. |               |

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**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

**D2750-043 350 SKIDTUBE ASSEMBLY, LH**

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2018 OCT 19

APPROVED

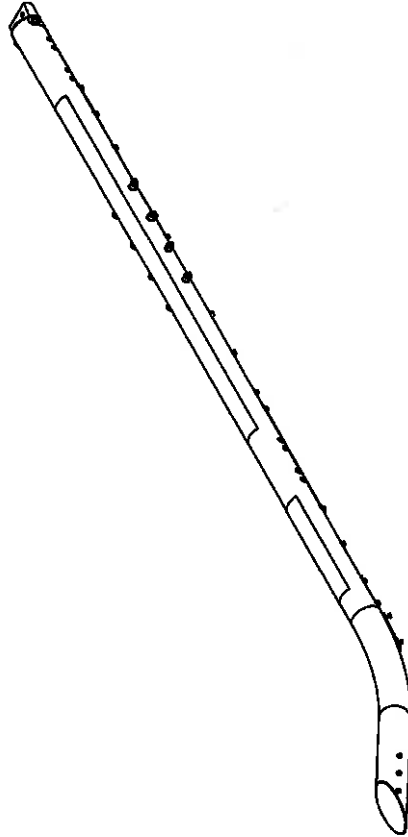
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| MFG. APPR.                                                                                                                                                                                      | DD       | D2750                                        | SHEET 3 OF 18 |
| APPROVED                                                                                                                                                                                        | NO       | TITLE                                        | SCALE         |
| DE APPR.                                                                                                                                                                                        | DS-1     | 350 SKIDTUBE ASSEMBLY                        | NTS           |
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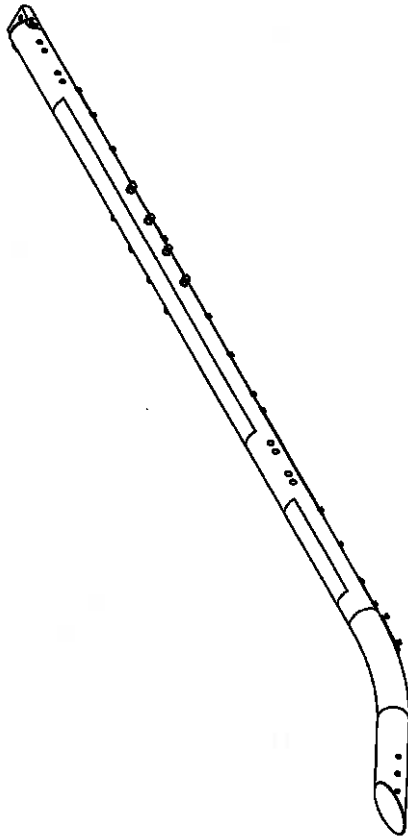
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C

A



**A** D2750-052 350 SKIDTUBE ASSEMBLY, RH



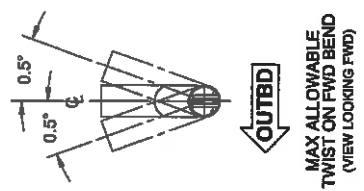
**A** D2750-051 350 SKIDTUBE ASSEMBLY, LH

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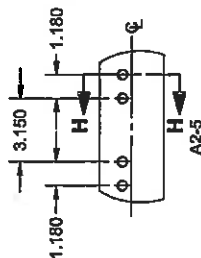
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| CHECKED    | MM       | DRAWING NO. D2750        |
| MFG. APPR. | DD       | REV. H SHEET 4 OF 10     |
| APPROVED   | NO       | SCALE                    |
| DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY    |
| DATE       | 18.03.05 | NTS                      |

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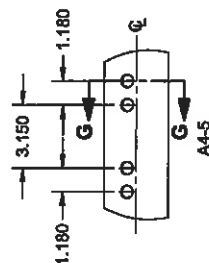


**MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEW LOOKING FWD)**

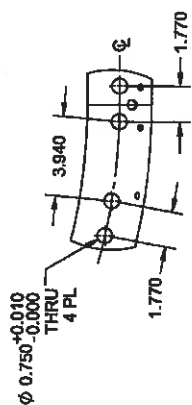
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**DETAIL A**  
**SCALE 2X**



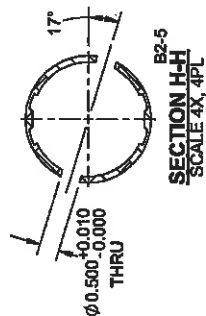
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**DETAIL D**  
**SCALE 2X**



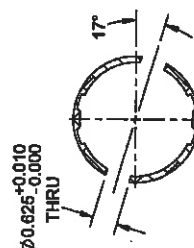
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**DETAIL C**  
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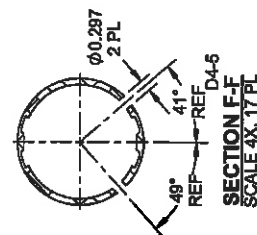
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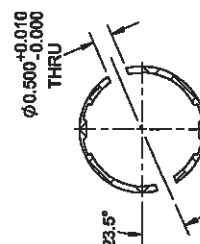
**B2-5**  
**SECTION H-H**  
**SCALE 4X, 4PL**



**B4-5**  
**SECTION G-G**  
**SCALE 4X, 4 PL**



**SECTION F-F**  
**SCALE 4X, 17 PL**

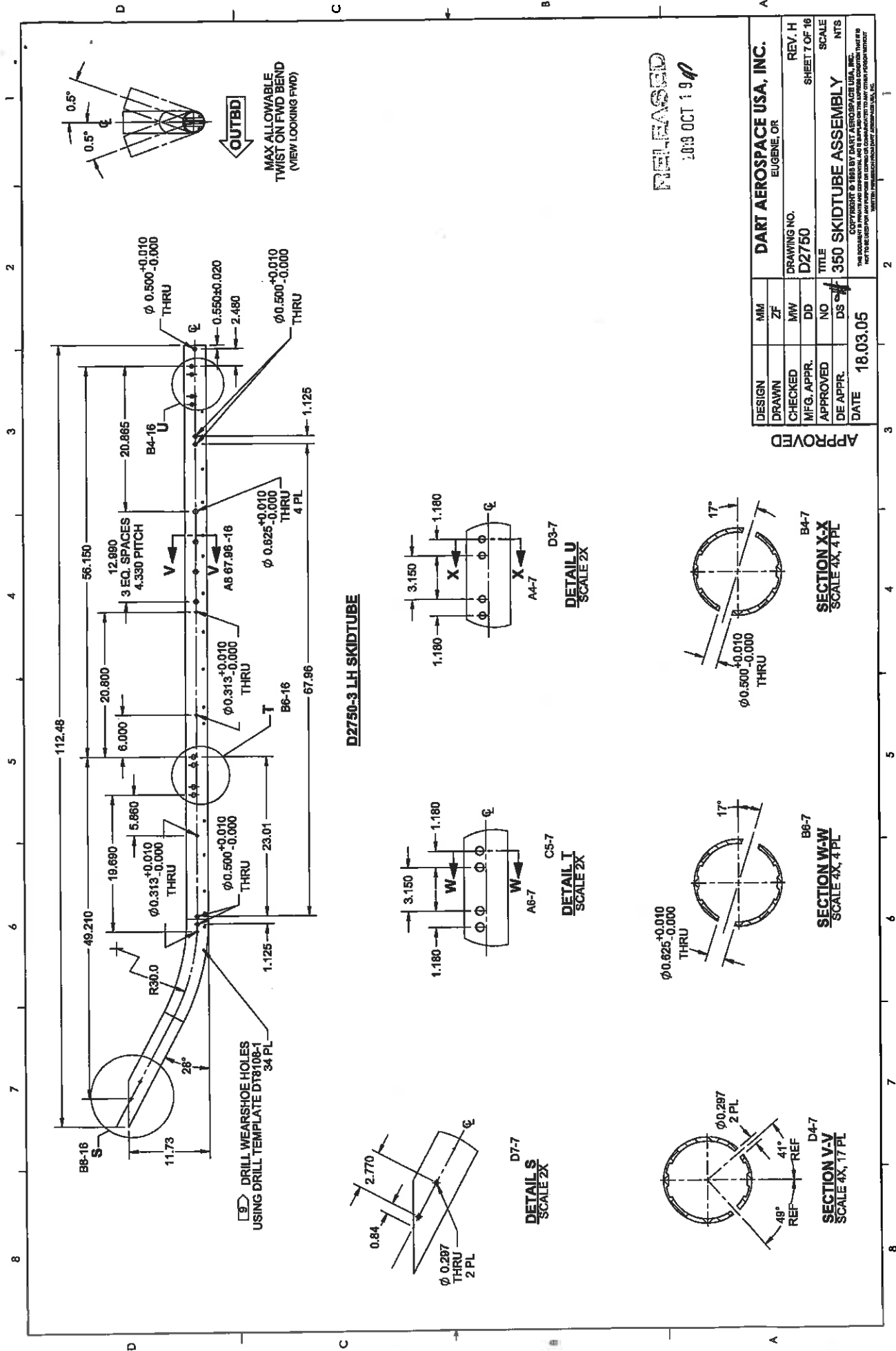


**D5-5**  
**SECTION E-E**  
**SCALE 4X, 2 PL**

|            |          |                                                                                                                                                                       |               |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
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| CHECKED    | MM       | DRAWING NO.                                                                                                                                                           | REV. H        |
| MFG. APPR. | DD       | D2750                                                                                                                                                                 | SHEET 6 OF 10 |
| APPROVED   | NO       | TITLE                                                                                                                                                                 | SCALE         |
| DE APPR.   | DS-4     | 350 SKIDTUBE ASSEMBLY                                                                                                                                                 | NTS           |
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**B4-10**  
**SECTION BS-BS**  
**SCALE 4X, 4 PL**

|            |          |                                                                                                                                |                |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------|----------------|
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| CHECKED    | MW       | DRAWING NO.                                                                                                                    | REV. H         |
| MFG. APPR. | DD       | D2750                                                                                                                          | SHEET 10 OF 16 |
| APPROVED   | NO       | TITLE                                                                                                                          | SCALE          |
| DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY                                                                                                          | NTS            |
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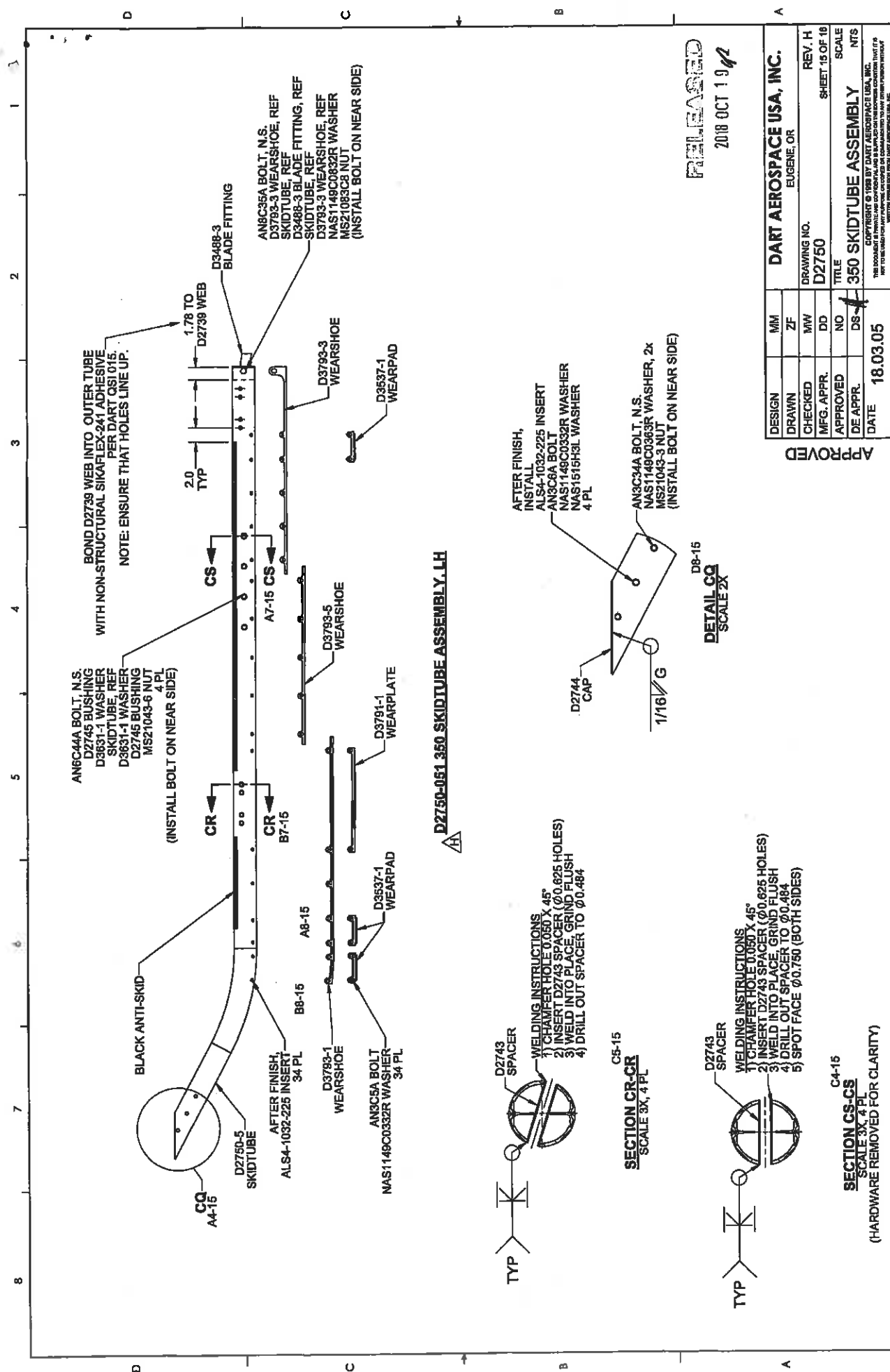
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PRELIMINARY  
2018 OCT 19

| DART AEROSPACE USA, INC. |          |             |                       | REV. H |
|--------------------------|----------|-------------|-----------------------|--------|
| DESIGN                   | MM       | DRAWING NO. | EUGENE, OR            |        |
| DRAWN                    | ZF       | D2750       |                       |        |
| CHECKED                  | MW       |             |                       |        |
| MFG. APPR.               | DD       |             |                       |        |
| APPROVED                 | NO       | TITLE       | 350 SKIDTUBE ASSEMBLY |        |
| DE APPR.                 | DS       | SCALE       | NTS                   |        |
| DATE                     | 18.03.05 |             |                       |        |



SECTION CR-CR  
SCALE 3X, 4 PL



SECTION CS-CS  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

DETAIL CQ  
SCALE 2X

D2750-051 350 SKIDTUBE ASSEMBLY, LH

**Part Number:** D350-636-011/-011GB/-012/-012GB

**Description:** SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

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